

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015803**Date Inspected:** 16-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** ZPMC and ABF**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG 13 section**Summary of Items Observed:**

Caltrans Quality Assurance Inspector (QAI) representative Mr. Wai Pau witnessed thirteen tack weld welders perform qualification testing for ZPMC.

The qualification welding tests utilizing the Shielded Metal Arc Welding (SMAW) process was conducted by each welders performed in the flat and vertical position (2F & 3F).

The names of test welders are Mr. Zhang Mang Xing, Zhai Qing Hua, Li Nan Ping, Li, Ke Xiang, Peng Shiz Hong, Chen Shao Ming, Fan Shuai, Jiang Peng Cheng, Dai, Yun Bo, Wang Guang Zhi, Hong Jie Fang and Yang Gang Gang.

-The material used for the welder qualification test specimens was reported by ZPMC inspector as ASTM A709M. Gr 345 plate having a wall thickness measurement of 12mm.

-The weld joint design used T-joint.

-The proper filler metal used in the test for SMAW is E7018 with 4mm diameter electrode.

-The welder qualification welding process was monitored and recorded by ZPMC inspectors Mr. Li Yan Hue (07120701).

After welding completion, the break test performed by the ZPMC CWI Mr. Li Yan Hue and Caltrans filed a lot number B240-039-10 for tracking propose. Base on Caltrans witnessing, the qualification welding tests appeared to be in compliance with requirements of AWS D1.5 2002 and Caltrans contract documents.

Summary of Conversations:

WELDING INSPECTION REPORT

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As notes within report above

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 15000026784 , who represents the Office of Structural Materials for your project.

Inspected By:	Pau,Wai	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
